

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018729**Date Inspected:** 07-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr.Zhu Zhong Hai.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

OBG TRIAL ASSEMBLY

This QA Inspector observed ZPMC qualified welding personnel identified as 067765, 058087 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 11DE Stiffener to Corner assembly plate, panel point 105 to 106 Cross beam side. Joint identified as SSD24-PP105.5-002. ZPMC QC Identified as Zhang Qiang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2112, WPS-B-P-2113 and WPS-B-P-2114.

This QA Inspector observed ZPMC qualified welding personnel identified as 047353 Perform Flux Core Arc Welding (FCAW) on OBG segment 11EE+12AE Edge plate to side plate hold back area of Cross beam side. Joint identified as CA093-005 and SEG3001AA-002. ZPMC CWI Identified as Liu Hua Jie. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2232-ESAB. For more information see below attached picture number 1.

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This QA Inspector observed ZPMC qualified welding personnel identified as 040320 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 11EE+12AE Edge plate to Deck plate hold back area. Joint identified as SEG3001AA-001 and CA093-006. ZPMC CWI Identified as An Qing Xiang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-Tc-U4b-FCM-1.

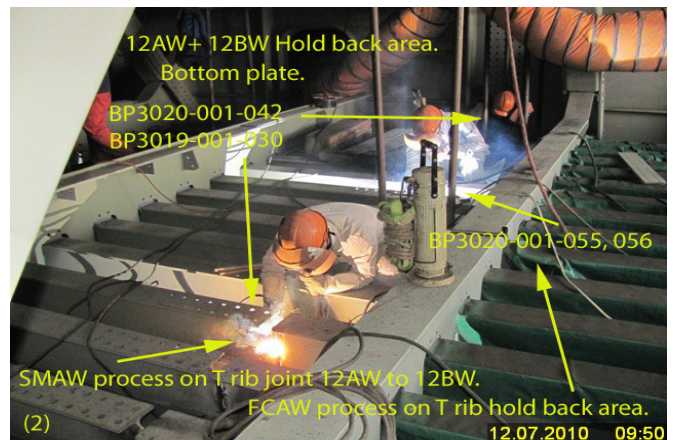
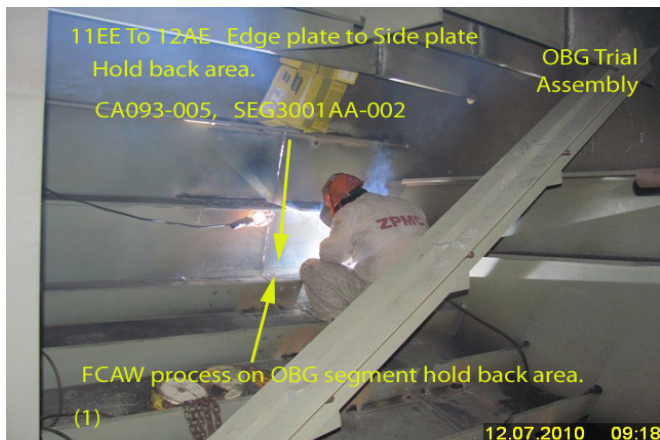
This QA Inspector observed ZPMC qualified welding personnel identified as 044551, 057333 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW + 12BW Hold back area. Joint identified as BP3019-001-030 and BP3020-001-042. ZPMC QC Identified as Shi Lei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2213-B-U2-FCM-1. For more information see below attached picture number 2.

This QA Inspector observed ZPMC qualified welding personnel identified as 053486 Perform Flux Core Arc Welding (FCAW) on OBG segment 12AW + 12BW Hold back area. Joint identified as BP3020-001-055, 056 and BP3023-001-013, 014. ZPMC QC Identified as Shi Lei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-ESAB.

This QA Inspector observed ZPMC qualified welding personnel identified as 046704, 041713 Perform Shielded Metal Arc Welding (SMAW) on OBG segment 12AW + 12BW Side plate Hold back area Cross beam side. Joint identified as SP3046-001-088, SP3037-001-158 and SP3035-001-191. ZPMC QC Identified as Shi Lei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2214-B-U2-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 049226 Perform Flux Core Arc Welding (FCAW) on OBG segment 12AW + 12BW Side plate Hold back area Cross beam side. Joint identified as SP3047-001-013, 014, and SP3051-001-001, 002. ZPMC QC Identified as Shi Lei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone :150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Shailesh
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Quality Assurance Inspector

Reviewed By:	Carreon,Albert
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QA Reviewer
